



Dart Aerospace Ltd.
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D3213-1
Job Sheet 190763



Part No: D3213-1

Job Qty: 8 pcs

Part Name: Door Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B IPP Rev:A 05-11-17 New Issue JLM IPP Rev:B 07-02-13 Now on Waterjet JLM IPP Rev C:
08.11.26 Comment added to step 2 KJ Verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		3/22/19	0.00	0.61	Waterjet - Flow		JRB 10/26/19
120	QC 8	8 pcs		3/22/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 47		
130	Small Fab - 2 - B4B	8 pcs		3/22/19	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
140	Handfinish - 1-1 Chemical-B4B	8 pcs		3/22/19	0.00	0.38	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		

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DART
AEROSPACE

Container No: S226751

Part: D3213-1
Job No: 190763
Serial No/Batch: S226751

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 10/26/19

N/R

OCT 28 2019
DAS
40
9-89

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NOV 12 2019

				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	QC 3	8	3/22/19	0.00 0.00	QC 3 - 10
		pcs			QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9
160	Packaging 3-1 - Stock - B4B	8	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B

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				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC
				Packaging 3 - 24 - B4B	ST 484
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-59
170 QC 21 - SA	8	3/22/19	0.00 0.00		
	pcs				

Part Op 100 - 1-Cut as per Dwg D3213
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab) Deburr
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC3- Inspect Part Finish)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

NOV 7 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	3.7712 sf (.4714 ea)	100-Waterjet - Flow - 1	5216341

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	4	66	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	15.000inches ± 0.030	15.030 14.970	15.000	
2	Door Panel	4.470inches ± 0.030	4.500 4.440	4.470	
3	Door Panel	14.400inches ± 0.005	14.405 14.395	14.400	
4	Door Panel	0.300inches ± 0.010	0.310 0.290	0.304	
5	Door Panel	0.128inches + 0.005 - 0.001	0.133 0.127	0.129	
6	Door Panel	2.057inches ± 0.005	2.062 2.052	2.06	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
		Completed By _____		Lead hand / Supervisor _____		QC / QA Coordinator _____	